

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009603**Date Inspected:** 06-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG Deck Panels				

Summary of Items Observed:

On this day Caltrans OSM Quality Assurance (QA) Inspector Stefan Holmes was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China.

Pursuant to NDT Inspection Notification (Document Number 003869), QA Inspector attempted to perform MT for Holdback welds in OBG CB2. Upon arrival QA Inspector found VT of welds unacceptable to AWS D1.5;2002. Welds found to contain significant undercut. QA Inspector performed visual inspection of hold back welds on the west and on the east of CB2. No MT performed, welding not ready. Incident report filed.

QA Inspector performed Final Visual Inspection following the guide lines of AWS-D1.5 on Deck Panel assemblies including Partial Penetration (PJP) welds joining U-ribs to deck plate. The deck panels examined are as follows:

DP129-002: Final VT appears to comply with code and contract requirements.
DP343-002: Final VT appears to comply with code and contract requirements.
DP129-001: Final VT appears to comply with code and contract requirements.
DP370-001: Final VT appears to comply with code and contract requirements.

Magnetic Particle Testing

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

OBG Components. The weld designations reviewed are as follows:

OBG

DP129-002-001-010

DP343-002-001-010

DP129-001-001-010

DP370-001-001-010

QA Inspector performed Green Tagging activities following the green tagging procedure. The deck panels green tagged are as follows:

DP370-001: Green Tag Number 7855

DP129-001: Green Tag Number 8037

DP129-002: Green Tag Number 7857

DP343-002: Green Tag Number 7856

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Holmes,Stefan
----------------------	---------------

Quality Assurance Inspector

Reviewed By:	Hall,Steven
---------------------	-------------

QA Reviewer
